

Work Order ID 74773

74773

Page 1

October 6, 2011 10:27:00 AM

Item ID: D3916-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 10/06/11 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/12/11 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *11/10/06* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

0.00

100

Large Fab

Memo

0.00

Large Fab

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg.D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

PL 11-11-09

(8x)

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

Suluico

(EE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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October 6, 2011 10:27:00 AM

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 10/06/11 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/12/11 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107 *107* Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M115778</u> Memo 1- weld bushing as per dwg D3916 ✓ 2- grind welds flush ✓	0.00 0.00							<u>11/11/10</u> (B)
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>Sulala</u>
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							<u>(X8)</u>

W/O:		WORK ORDER CHANGES					
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Work Order ID 74773

October 6, 2011 10:27:00 AM

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Page 3

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 10/06/11 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/12/11 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten notes and signatures:
 11/11/11
 Basket coll
 11/11/11
 11/11/11
 11-11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 6, 2011 10:27:05 AM

Page 1

Work Order ID: 74773

74773

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 10/06/11

Required Date: 10/12/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

91.0000

7

42

D3759-1

Bushing

**

Handwritten signature and date 11/11/10

Location

Loc Qty

Loc Code

WA

89

72316

89

WA005

2

66489

2

Handwritten circled number 562

M304TS0.750W.049

Purchased

No

100

f

565.4164

4.166

~~26.31158~~

35.0819

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

Handwritten signature and date 11/11/09

Location

Loc Qty

Loc Code

MAT018

496.4991839

117775

93.6739

118472

51.5848839

118880

51.2404

119147

300

MAT034

1.8507

117337

1.8507

WA

67.06654

118184

67.06654

Handwritten numbers 8.7704 and 26.3115

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

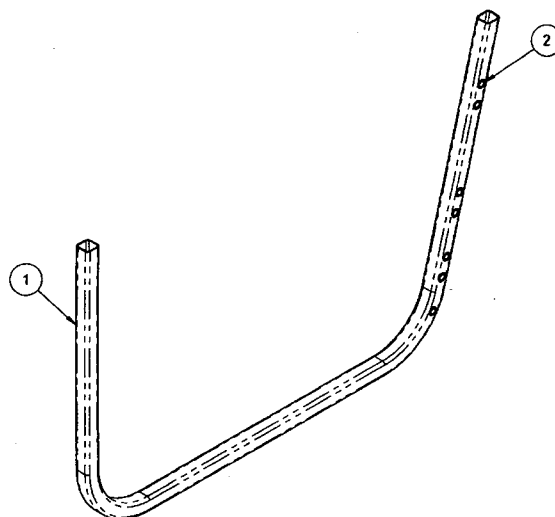
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

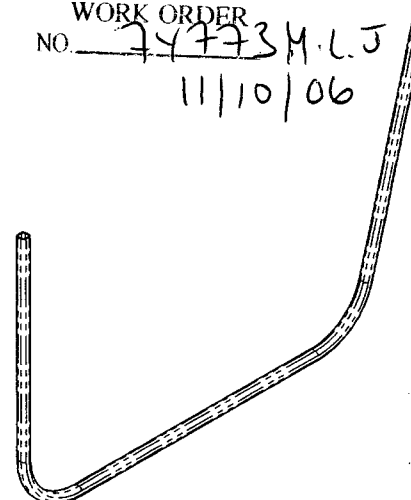
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24773 M.L.J
11/10/06



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK 10.12.21
~~UNDER REVIEW~~
10.10.11
ADDITION OF HOLE + BUSHINGS
ON D3916-041-1 RIBS.

RELEASED
2010-03-12
JNP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	JNP	D3916	SHEET 1 OF 4
APPROVED	JNP	TITLE	SCALE
DE APPR.	JNP	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

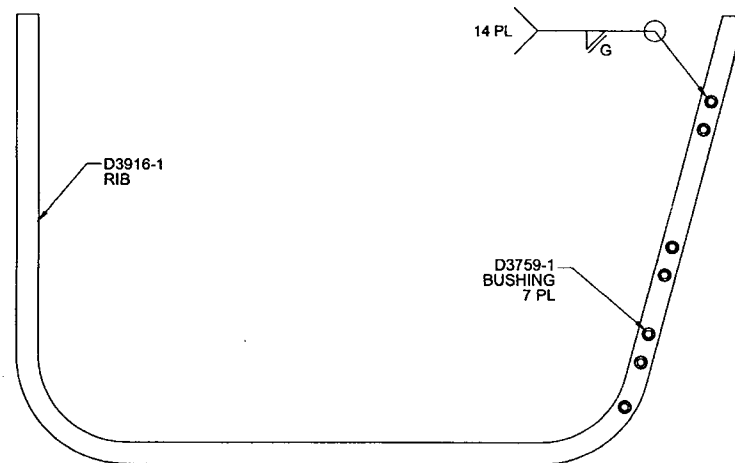
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

74773



D3916-041 RIB ASSY

RELEASED
2010-03-12
ANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
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DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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NOTE: Date & initial all entries

8 7 6 5 4 3 2



9 D3916-1 RIB

0.049
B55

SECTION A-A

RELEASED
2010-03-12

NOTES:

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.76 lbs
 - 9) TUBE FLAT LENGTH 50.0 REF

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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR. *	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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8 7 6 5 4 3 2

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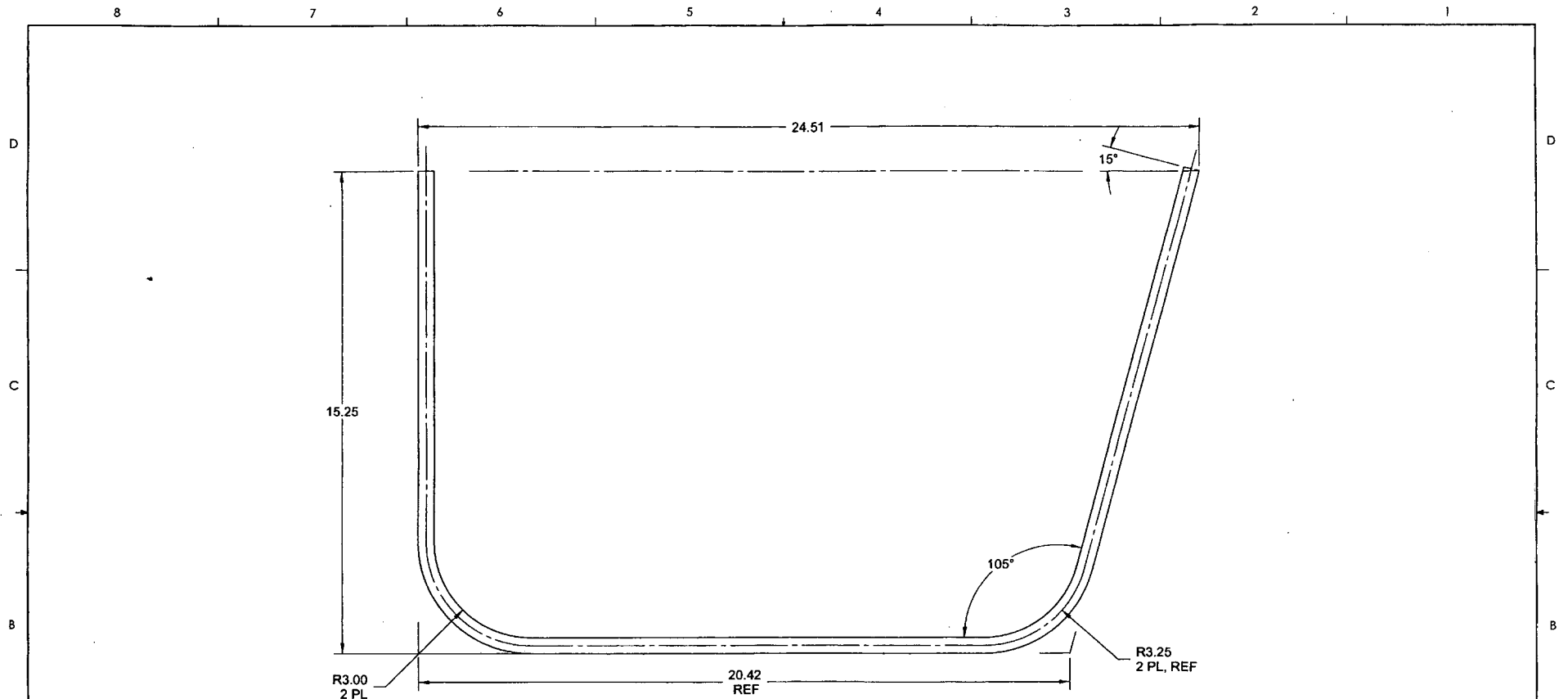
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NOTE: Date & initial all entries

74773







9 D3916-5 LIGHT RIB

RELEASED
2010-03-12
JPH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
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